

Work Order ID 62362

Tuesday, September 28, 2010 11:53:14 AM



Page 1

Item ID: D3929-041

Accept



Setup Start



Revision ID:

Item Name: Gusset Assembly

Stop



Start Date: 9/28/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 10/5/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 10/9/20

Tooling:

Date:

Run Start



QC:



Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3929	Rev A								
100		0.00							
									
Waterjet		0.00							
FLOW CNC Waterjet									
304 .125									
	Memo								
	1-Cut as per Dwg D3929								
	Dwg Rev: A								
	Prog Rev: A								
	2-Deburr if necessary								
110		0.00							
									
QC		0.00							
Quality Control									
	Memo								
	QC2- Inspect parts off machine FAI/FAIB								

HB 10-9-29

6

HB 10-9-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Reference:

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Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

6

1009.30

140

0.00



Large Fab

Memo

0.00

Large Fab

Weld bushings D3907-1 as per dwg D3929

316L rod batch: 111585

6/10.10.15

150

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

6 PD 10.10.15

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Stop

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Required Date: 10/5/2010 Req'd Qty: 6.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

6 10-10-15

170

Identify as per dwg & Stock Location: WA

0.00



Packaging

Memo

0.00

Packaging

SAP 10-10-15



180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/10/18 MF 10-10-18

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Picklist Print

Tuesday, September 28, 2010 11:53:19 AM

Page 1

Work Order ID: 62362

Parent Item: D3929-041

Parent Item Name: Gusset Assembly



Start Date: 9/28/2010

Required Date: 10/5/2010

Start Qty: 6.00

Required Qty: 6.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S11GA

Purchased

No

100

sf

63.9423

0.45

2.842105



304/316 0.125 Sheet



18 10-9-29

Location

Loc Qty

Loc Code

MAT

63.9423

114799

63.9423

D3907-1

Manufactured

No

130

Each

5.0000

2

12



Bushing



114799

⑥

10-10-15

Location

Loc Qty

Loc Code

WA

5

60720

5

⑤

362149 x 12

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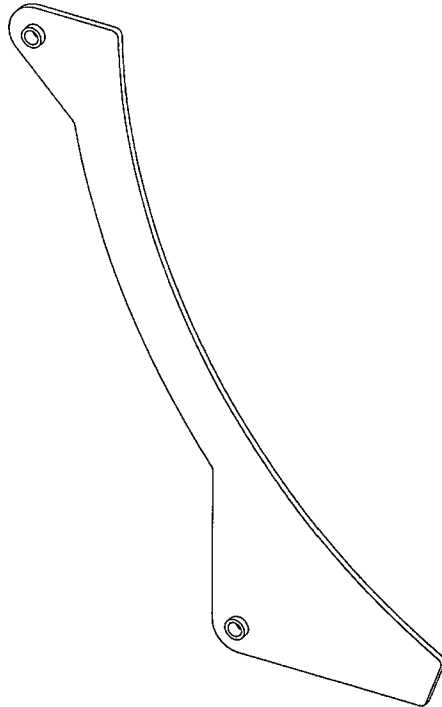
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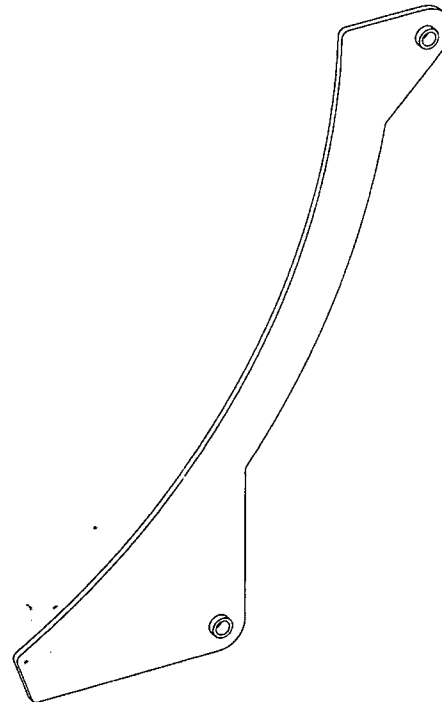
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ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3929-041	GUSSET ASSEMBLY
2		X	D3929-042	GUSSET ASSEMBLY
11	2	2	D3907-1	BUSHING
12	1	1	D3929-1	SUPPORT GUSSET



D3929-041 GUSSET ASSEMBLY



D3929-042 GUSSET ASSEMBLY

STANDARD
UNCONTROLLED
SUBJECT TO APPROVAL
WELDING WORK
NO. *67362*
PS 10-928

RELEASED
07/04/12

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3929-04X" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.73 lbs EACH
 - 8) WELDING: PER DART QSI 004

A	NEW ISSUE	MB	09.04.03	
REV.	DESCRIPTION	BY	DATE	
DESIGN	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3929 TITLE GUSSET ASSEMBLY	REV. A	SHEET 1 OF 3	
DRAWN		SCALE	NTS	
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MFG. APPR.				
APPROVED				
DE APPR.				
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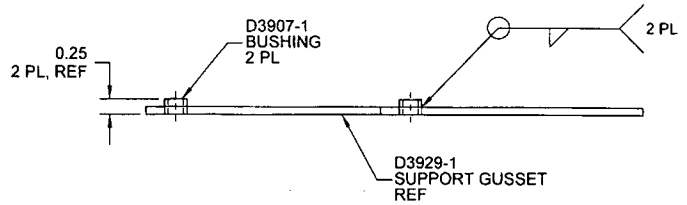
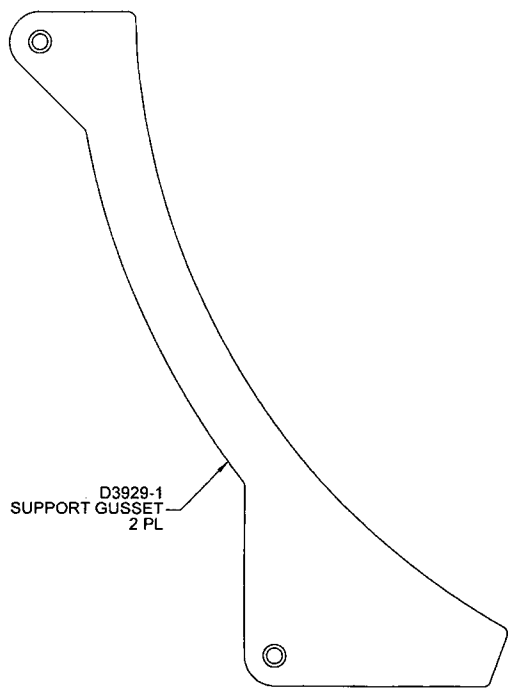
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C

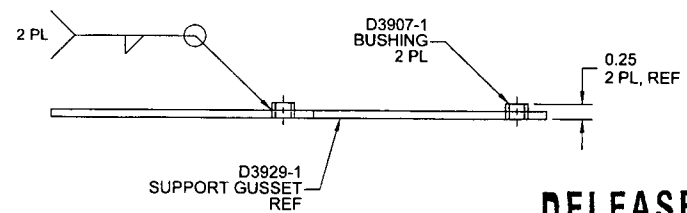
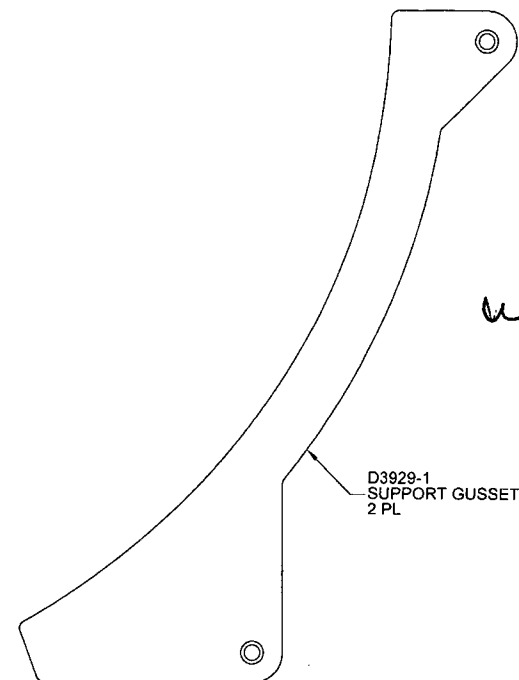
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D3929-041 GUSSET ASSEMBLY

w/o 62302



D3929-042 GUSSET ASSEMBLY

RELEASED
09/04/22

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO. D3929	REV. A
MFG. APPR.		TITLE	SHEET 2 OF 3
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DE APPR.			NTS
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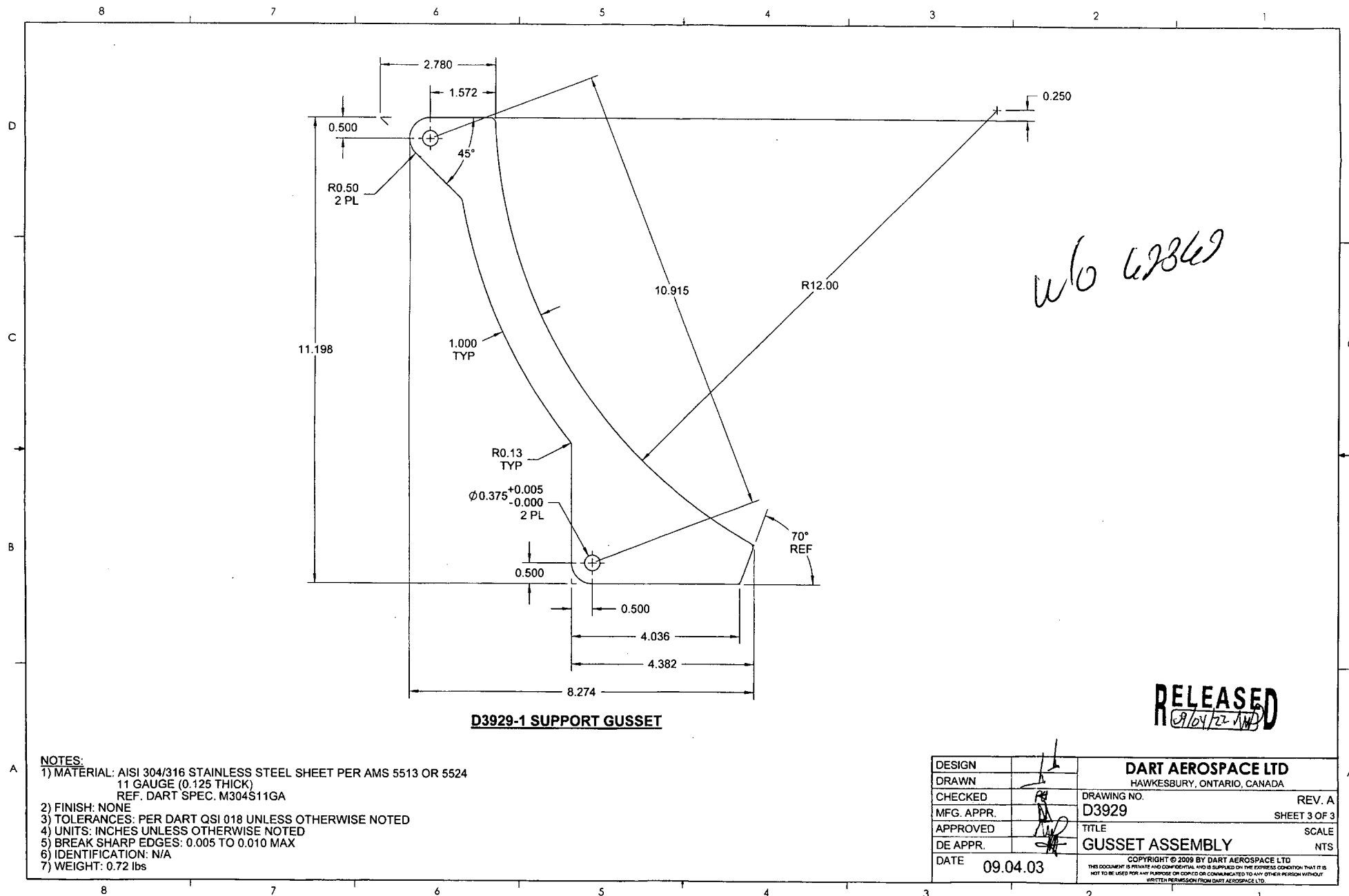
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